

Work Order ID 91816

91816

Page 1

October-19-12 11:16:34 AM

Item ID: D2500-1-190

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ext'n -1" Beam Tube 4"

Start Date: 10/18/12 Start Qty: 80.00

80

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

RP

Date:

12-10-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2500	Rev H								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <i>18204</i>								
	a) Extrude as per Dwg D2500								
	b) Material: 6061-T6 (QQ-A-200/8)								
	c) Minimum yield tensile strength = 35 ksi								
	d) Minimum ultimate tensile strength = 38 ksi								
	e) Minimum elongation = 8%								
	f) Order at 190" long								
	g) Bon L Canada Inc. tool # 897105								
	h) To be packed per DSK 066								
	i) Pull test to ASTM standard B221 required.								
	j) Material certification is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

CZ 12/10/22 (80)

10/12/12 (87)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
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Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 91816

91816

Page 2

October-19-12 11:16:34 AM

Item ID: D2500-1-190

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ext'n - 'I' Beam Tube 4"

Start Date: 10/18/12 Start Qty: 80.00

80

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester

0.00

130

Identify as per dwg & Stock Location: LC

0.00

130

Packaging

Packaging

* Pull Qc + 20 PCS Per QC inspect & Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

W/2.11.14

QC 12/11/13

12/11/14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

October-19-12 11:16:34 AM

Page 1

Work Order ID: 91816

Parent Item: D2500-1-190

Start Date: 10/18/12

Required Date: 10/26/12

Parent Item Name: Ext'n -'I' Beam Tube 4"

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: G 02.09.05 Added DSK 066 KJ/RF
IPP: H 07.07.06 rev G dwg EC IPP Rev: I as per dwg revH DD
10.02.23 verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190P Ext'n -'I' Beam Tube 4"		Purchased	No			110	Each	0.0000	1	80		10/24/12 (87)	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY			
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SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.066 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 897105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18868

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:

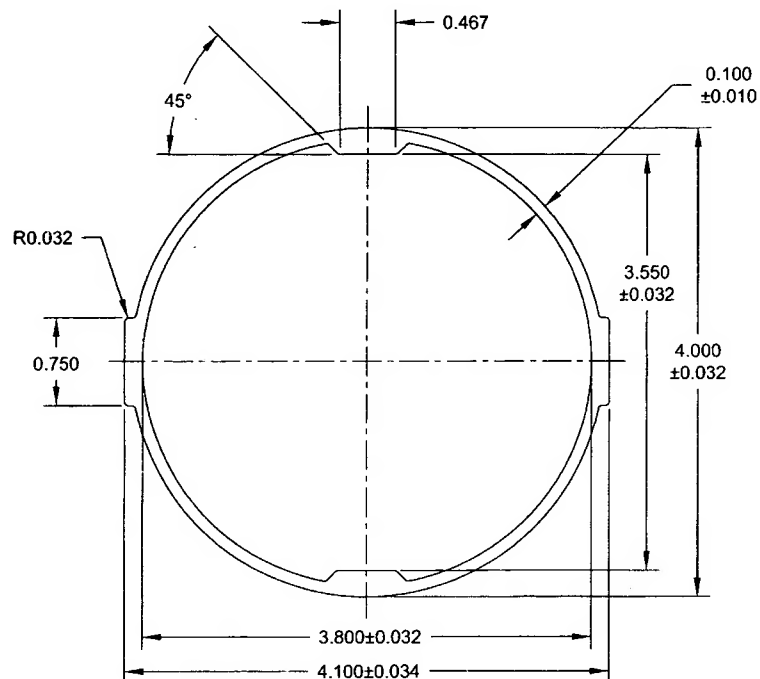
- A) CARADON INDALEX DIE # MS-18867

9/8/16
R12-10-19

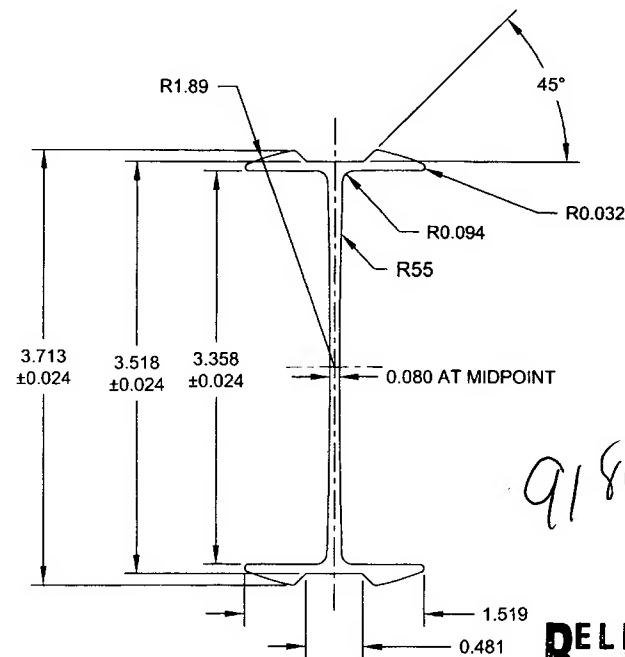
RELEASED
2010-02-03
MJP

H	REDRAW & REFORMAT DWG; CORRECT BON L DIE # TYPO (ZN B8-1), ADD AMS & ASTM MAT'L OPTION (ZN D8-1), TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & 'DIMS IN INCHES' NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.09.29
E	CHANGE MATERIAL TEMPER	DS	96.10.24
D	ADD MATERIAL PROPERTIES	DS	96.10.07
C	ADD D2500-3 WEB	BW	96.04.26
B	CHANGE INTERNAL WEB	DS	96.03.24
A	NEW ISSUE	DS	96.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN	4		
DRAWN	PH		
CHECKED	MJP		
MFG. APPR.	1/1		
APPROVED	4		
DE APPR.			
DATE	09.07.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. H	
D2500		SHEET 1 OF 2	
TITLE		SCALE	
EXTRUSION		NTS	
COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1









D2500-1



D2500-3

91816

RELEASED
2010-02-02

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2500	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	09.07.16	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1033

PURCHASE ORDER

Purchase Order ID PO18204

Purchase Order Date 10/22/12

PO Print Date 10/23/12

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

\$ + date

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2500-1-190P	Ext'n - T Beam Tube 4"	11/16/12 Yes	80.00 Each	Yours ppd	\$82.9265	\$6,634.12

Special Inst:

EXTRUDE AS PER DWG D2500 REV.H
B85483
MATERIAL: 6061-T6 (QQ-A-200/8)
MINIMUM YIELD TENSILE STRENGTH
= 35 KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%
190" LONG
SIGNATURE ALUMINUM TOOL: #
897105
TO BE PACKED PER DSK 066
PULL TEST TO ASTM STANDARD B221
REQUIRED

Net 87

PO Total:

\$6,634.12

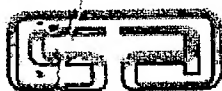
MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr: 2

Change Date: 10/23/12



**signature
aluminum
CANADA INC.**

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE / DATE DU BODEREAU
11-06-12

MANIFEST NUMBER / N° DE BODEREAU
008212

SALES ORDER NUMBER / N° DE COM
107831

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	WILRIDE	042		G.ATTENBOROU
JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE
		G.ATTENBOROU		DLB
CARRIER / TRANSPORTEUR				
WILRIDE				

CUSTOMER ID / ID DU CLIENT
46024

ORDER DATE / DE LA
COM
10/22/12

CUSTOMER PO NUMBER / CLIENT PO Nombre

18204

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

008212

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	2,144	LB		DAA-897105-2	6061 T6		4	2,335	2,246	LB	
	973	KG		D2500-1-190	190.0000 IN			1,059	1,019	KG	
	80	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			87	PC	

						817658 / 159824	1	483	461		18 PC
						817658 / 159825	1	617	595		23 PC
						817658 / 159826	1	617	595		23 PC
						817658 / 159827	1	617	595		23 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

4	2,335	2,246	LB
	1,059	1,019	KG
		87	PC
TOTALS			

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

11/04/2012		5292867		107831		1	
18204		008212		817658		11/06/12	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA				46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA			
Item No.	DAA-897105-2			190" Mill 6061 T6			D2500-1-190
Gross Weight	2,335 LBS						
Net Qty	2,246 LBS			87 PCS			4 PKGS
Specification	AMS QQA 200/9 + ASTM B221-08						

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
300.0 / 43.5	271.8 / 39.4	8.7	N/A	93

Chemical Analysis:

8/12/12

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.63	0.29	0.22	0.05	0.88	0.06	0.06	0.02	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc